

Work Order ID 84927

\*84927\*

Page 1

May-29-12 2:52:00 PM

Item ID: D209-669-043

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Replacement Skidtube

Stop

\*NS2\*

Start Date: 29/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/29

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2906	Rev B

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002 per QSI 12-599

110

0.00

\*110\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- Inspect mat'l D2500-1-190 for damage

-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

-Open holes to 0.500" as per Dwg D2906 without cutting fluid

-Deburr and blow out all chips from

-Acid etch and Alodine tube per QSI 005 4.1

> CF 12-6-11

> SAT 12-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84927

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May-29-12 2:52:00 PM

Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Skidtube

Stop **\*NS2\***

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC3- Inspect Part Finish

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*[Signature]* 12-6-11

130

0.00

**\*130\***

Skidtubes

Skidtubes

Memo

0.00

-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date: 13-4-12

Start Time: 14:00 Date: 12-6-11

Fin Time: 8:00 Date: 12/07/09

pick:

Qty	P/N	description	B/N
1	D2926-3	Web	B84950

B/N  
B84950

1 CF 12-6-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00

**\*140\***

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - CROSSTUBES

Memo

0.00

1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT

2-Cut tubes as per Dwg. D2906

*Handwritten: DP 12-6-13*

150

0.00

**\*150\***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

-Deburr ends and remove marks from bending

- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention.

*Handwritten: SAN 12-06-13*

*Handwritten: CF 12-6-14*

*Handwritten: BB 12/07/04*

*Handwritten: PTO*

160

0.00

**\*160\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

*Handwritten: 1 0 12/07/09*

W/O: 84927		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D209-609-043 PAR #: \_\_\_\_\_ Fault Category: inspection NCR: Yes No DQA: 12/21/24 Date: 12/07/24  
 Resolution: \_\_\_\_\_ Disposition: Re-work QA: N/C Closed: 12/7/24 Date: 12/7/24

NCR: 12-1617		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-6-18	150	Found at insp. that <sup>2</sup> x-bolt spacers were crabs.  RC: Annealed x-bolt spacers were T6, should have been T4. Missed at insp.	W 12/6/18	Remove 19 x-bolt spacers (T6) and replace with <u>T4</u>	<u>12-6-18</u>	CF 12-6-18	CP 12/6/18 09042	S 12/6/18

NOTE: Date & initial all entries

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**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00

**\*170\***

Large Fab

Skidtubes

Memo

0.00

Skidtubes

-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Debur

-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Debur

-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Debur

① SAD 6-07-09

190

QC5- Inspect part completeness to step on W/O

0.00

**\*190\***

QC

Memo

0.00

Quality Control

8/7/09

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

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Stop **\*NS2\***

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Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Pressure Wash per QSI005 4.3	0.00							
<b>*200*</b>									
HandFinish	Memo	0.00				1	76	12.79	
Hand Finishing									
210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*210*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:20 OVEN TEMPERATURE: 3200F FINISH TIME: 7:50								
220	QC3- Inspect Part Finish	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									

M121841

IX 12/07/10

1 12/07/11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*84927\***

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Item ID: D209-669-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 29/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 <u>121136</u> Sikaflex expire date: <u>4/03</u>								
	2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906								
	3-Inspect for foreign object per QSI 024								
	4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 <u>121136</u> Sikaflex expire date: <u>4/03</u>								
	5-Wing Walk as per Dwg D2906 and QSI 005 4.4 Batch: <u>122320</u>								

1 ~~8~~ SP 12/07/11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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May-29-12 2:52:00 PM

**\*84927\***

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Item ID: D209-669-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube  
 Start Date: 29/05/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 16/07/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 <b>*240*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00 0.00		8.17/12/12					
250 <b>*250*</b> Packaging Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPPD209-669-043 Location: _____ PPP Rev: <u>PPP</u> 84919	0.00 0.00							
260 <b>*260*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

*8.17/12/12*

*MLJ 12/07/23*

*U 12.07.23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

May-29-12 2:56:06 PM

Page 1

Work Order ID: 84927

\*84927\*

Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 *D4202-1* Spacer		Manufactured	No	B84763 B832263			Each	81.0000	(19) **	19 (2)		DC 12/07/11 CF 12-6-14	
				<u>Location</u>				<u>Loc Qty</u>					
				LG				5					
				77727				5					
				LG002				76					
				78806				6					
				79810				70					
D2500-1-190 *D2500-1-190* Ext'n -1" Beam Tube 4"		Manufactured	No			110	Each	91.0000	1 **	1 (17)		DC 12/06/11	
				<u>Location</u>				<u>Loc Qty</u>					
				HALL				91					
				74777				14					
				80061				77					
D2926-3 *D2926-3* Web		Manufactured	No			110	Each	0.0000	1 **	1 (1)		CF 12-6-11	
D2855 *D2855* Cap		Manufactured	No			230	Each	21.0000	2 **	2 (2)		12/07/11	
				<u>Location</u>				<u>Loc Qty</u>					
				FP002				21					
				65519				2					
				73347				16					
				75074				3					

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A Purchased No

230 Each

1,090.000 4

**\*AN3-5A\***

Bolt

\*\*

4

28

12/07/11

## Location

## Loc Qty

## Loc Code

ST350

1090

115371

46

117423

124

118626

31

119355

200

120187 ✓

500

121185

189

AN960JD10L \* NAS1149D0332J ✓ Purchased

No

230 Each

0.0000

4

4

**\*AN960JD10I \***

Washer

121011 ✓

\*\*

4

28

12/07/11

ALS7-1032-130 Purchased

No

230 Each

2,136.000

44

44

**\*AIS7-1032-130\***

Insert

\*\*

44

28

12/07/11

## Location

## Loc Qty

## Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

2085

119530

73

120181

12

121444 ✓

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

230 Each

1,458.000 44 44

**\*AN3C4A\***

BOLT

\*\*

44

(28)

12/07/11

Location

Loc Qty

Loc Code

ST350

1458

120187

57

120521

28

120769

38

121205

1000

121556

335

AN960C10L ~~✗~~ NAS1149C0332 ☒ Purchased No

230 Each

0.0000 44 44

**\*AN960C10I \***

washer

D2594-3

Manufactured No

230 Each

2,418.000 14 14

**\*D2594-3\***

O-Ring, 205 Skidtube

\*\*

44

(28)

12/07/11

122063 ✓

Location

Loc Qty

Loc Code

FP001

2418

65518

41

79496

984

79573

50

79755 ✓

1343

May-29-12 2:56:06 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

230

Each

311.0000

14

14

**\*D2594-1\***

Plug, 205 Skidtube

\*\*

14

(SP)

12/07/11

Location

Loc Qty

Loc Code

FP001

84951 ✓

98

73401

30

74442

18

79495

50

FP-A

213

73401

0

78590

213

D3564-9

Manufactured No

230

Each

22.0000

1

1

**\*D3564-9\***

Wearshoe

\*\*

1

(SP)

12/07/11

Location

Loc Qty

Loc Code

FG

84870 ✓

4

76950

4

FP001

18

67590

4

69943

1

82255

13

D3564-11

Manufactured No

230

Each

8.0000

1

1

**\*D3564-11\***

Wearshoe

\*\*

1

(SP)

12/07/11

Location

Loc Qty

Loc Code

FG

83910 ✓

4

77056

4

FP001

4

80341

4

May-29-12 2:56:06 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-29-12 2:56:06 PM

Page 5

Work Order ID: 84927

**\*84927\***

Parent Item: D209-669-043

**\*D209-669-043\***

Parent Item Name: Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

230

Each

13.0000

1

1

**\*D3564-5\***

Wearshoe

\*\*

1

SP

12/07/11

## Location

## Loc Qty

## Loc Code

FG

84869✓

2

34806

2

FP001

11

77609

3

82254

8

D3566-1

Manufactured No

230

Each

31.0000

2

2

**\*D3566-1\***

Gasket

\*\*

2

SP

12/07/11

## Location

## Loc Qty

## Loc Code

FP

86240✓

-22

81619

10

FP002

53

68924

2

80919

3

83898

16

D3566-5

Manufactured No

230

Each

21.0000

1

1

**\*D3566-5\***

Gasket

\*\*

1

SP

12/07/11

## Location

## Loc Qty

## Loc Code

FP

84881✓

12

82275

12

FP002

9

80374

3

82274

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



B

B

B

B

QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

## GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

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WORK ORDER  
NO. 84923-145-29  
12/05/29

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07.09.04

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	q	DART AEROSPACE LTD	
DRAWN	C.B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 1 OF 3
APPROVED	14	TITLE	SCALE
DE APPR.	14	AH-1 (209) SKIDTUBE ASSEMBLY NTS	
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# Dart Aerospace Ltd

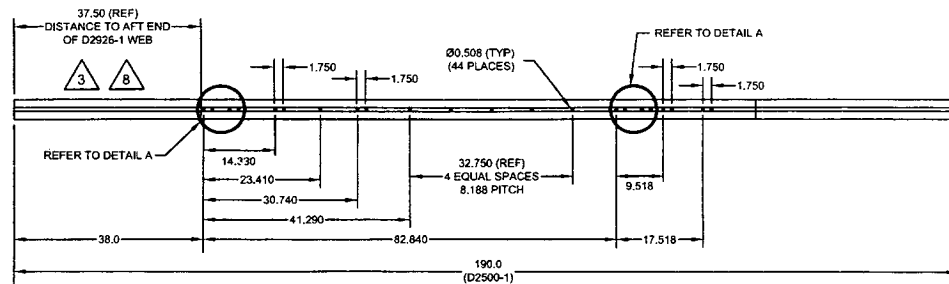
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

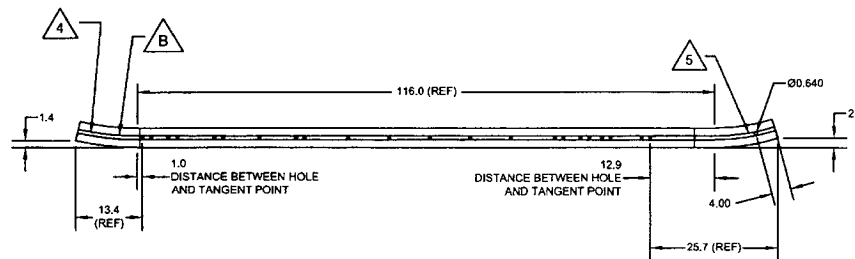
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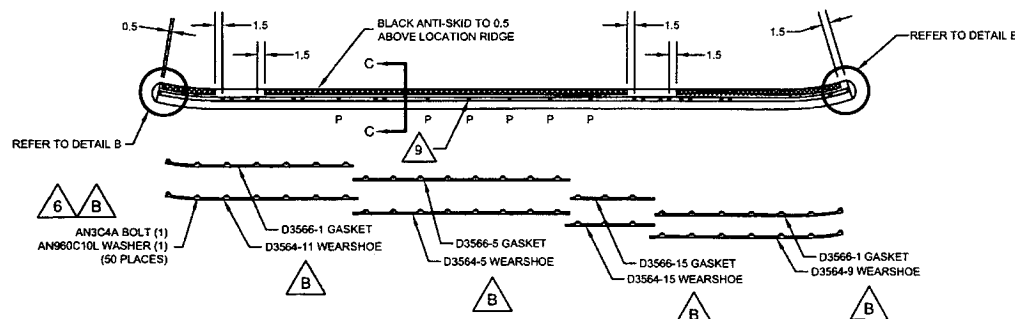
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**D2906-1 DRILLING DETAIL**

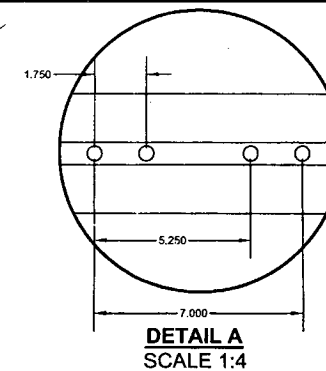


**D2906-041 BENDING AND CUTTING DETAIL**

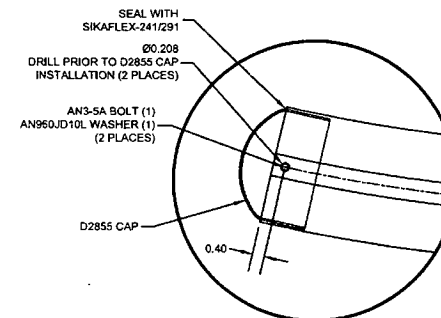


**D2906-041 ASSEMBLY DETAIL**

84927



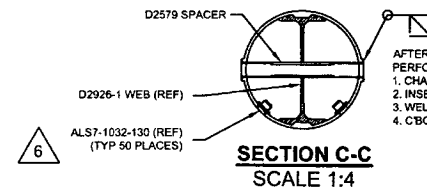
**DETAIL A  
SCALE 1:4**



**DETAIL B  
SCALE 1:4**

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**SECTION C-C  
SCALE 1:4**

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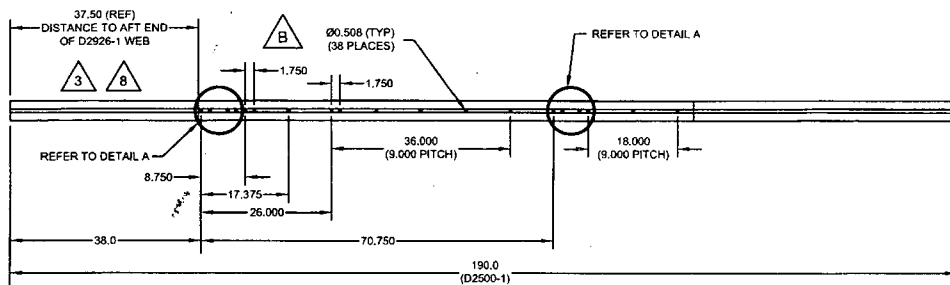
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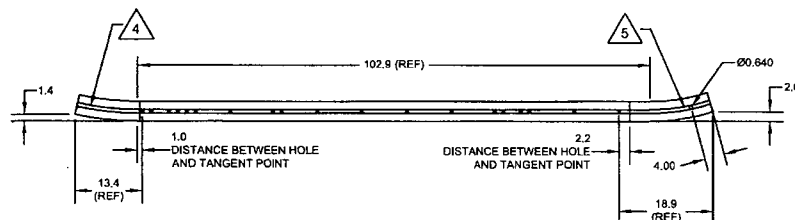
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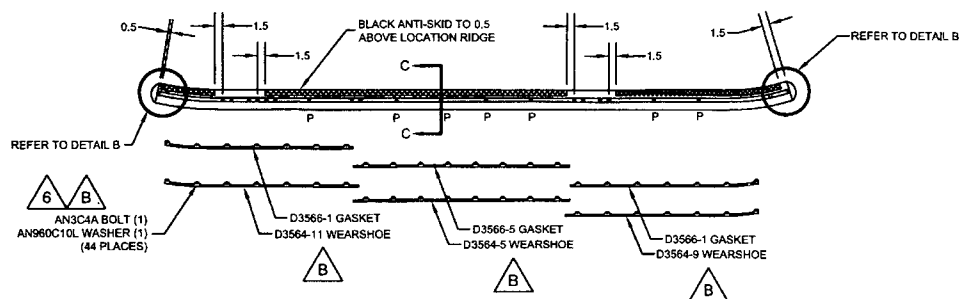
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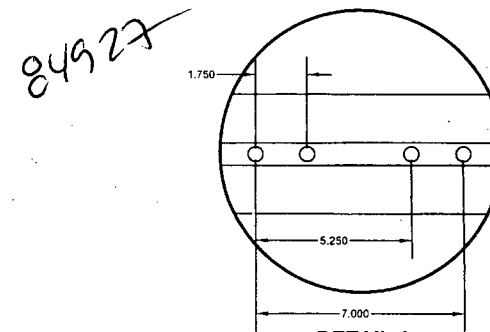
**D2906-3 DRILLING DETAIL**



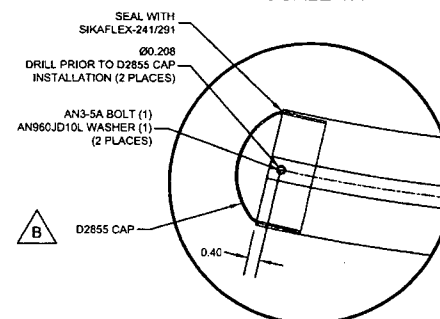
**D2906-043 BENDING AND CUTTING DETAIL**



**D2906-043 ASSEMBLY DETAIL**



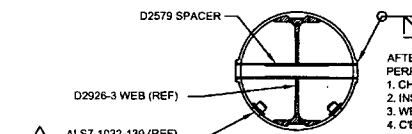
**DETAIL A**  
SCALE 1:4



**DETAIL B**  
SCALE 1:4

**RELEASED**

07.09.04



**SECTION C-C**  
SCALE 1:4

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (22 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

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